

Date: Tuesday, 07/04/2009 10:35:09 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PANEL
Job Number : 47019	
Estimate Number : 13101	
P.O. Number :	Part Number : D36551
This Issue : 07/04/2009 S.O. No. :	Drawing Number : D3655 REV. B
Prsht Rev. : NC	Project Number : 00204
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 39708	Material :
Written By :	Due Date : 24/04/2009 Qty: 4 Um: Each
Checked & Approved By : <u>JUD 09.04.07</u>	
Comment : Ext. Rev. A 07/12/13	
Est Rev:B 08-03-06 prototype DD verified by:EC	
Est Rev:C 08-04-07 revA DD verified by:EC	
Est. Rev. D 08/08/16 Dwg. Update. DL	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MLEXS093F600607	GE PLASTICS LEXAN SHEET
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MAT NOT PULLED



Comment: Qty.: 3.7134 sf(s)/Unit Total : 14.8537 sf(s)
 GE PLASTICS LEXAN SHEET 107574
 batch ~~107574~~ HB 9-4-15

2.0	WATER JET	FLOW WATER JET
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PB

Comment: FLOW WATER JET
 1-Cut as per Dwg D3655
 Dwg Rev: B
 Prog Rev: B

HB 9-4-15

6

2-Deburr if necessary

3AD 09-04-16 6

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 9-4-15

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

509/04/16 (x6)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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9

Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: 24/11

9/4/17

SD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3655-1 PAR #: N/A Fault Category: Prod / FAB ASSY med & Small NCR: Yes No DQA: D Date: 09/04/20
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: D Date: 09/04/21

NCR: <u>47019</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/4/15	# 20	During inspection it was found that the wrong mat. was used. Mat. color can should be	<u>BSIUR</u>	Material color is not the same as the rest. Un-acceptable. scrap qty 6 & Replace with the light grey as per chg..	<u>BS</u> 9-4-15	<u>S</u> 09/04/15	<u>BSIUR</u>	<u>BS</u> 09-04-15
		light grey parts were cut with Dark Grey. R.C. water set operator assured that the mat. was the same.	<u>BSIUR</u>	Replace on this w/o B# <u>M107524</u>			<u>BSIUR</u>	<u>BS</u> 09-04-15

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:35:09 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 47019

Part Number: D36551

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

Log 104/20

Job Completion



Log 104/17

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

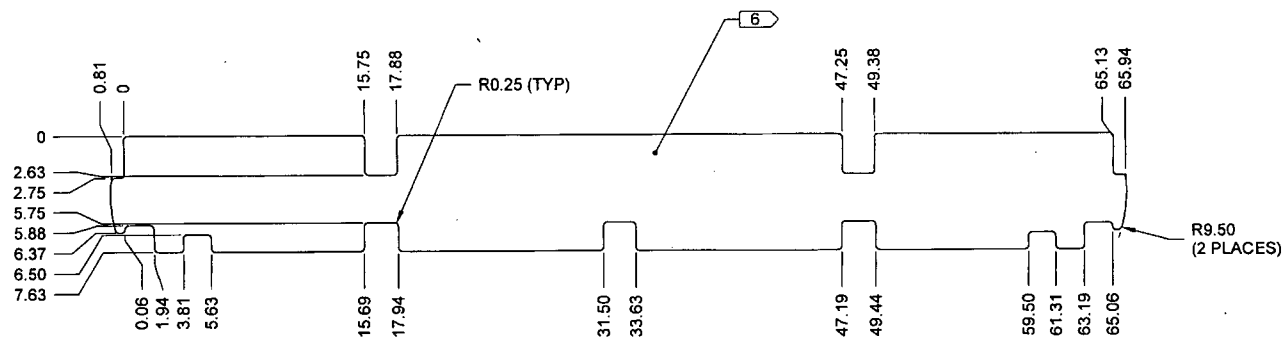
DART AEROSPACE LTD		Work Order: 4709
Description: Panel		Part Number: D3655-1
Inspection Dwg: D3655	Rev: AB	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.63	+/-0.030	2.635	X			
2.75	+/-0.030	2.758	X			
5.75	+/-0.030	5.766	X			
5.88	+/-0.030	5.883	X			
6.37	+/-0.030	6.384	X			
6.50	+/-0.030	6.512	X			
7.63	+/-0.030	7.639	X			
1.94	+/-0.030	1.951	X			
3.81	+/-0.030	3.822	X			
5.63	+/-0.030	5.640	X			
15.69	+/-0.030	15.69	X			
15.75	+/-0.030	15.75	X			
17.88	+/-0.030	17.875	X			
17.94	+/-0.030	17.94	X			
31.50	+/-0.030	31.50	X			
33.63	+/-0.030	33.625	X			
47.19	+/-0.030	47.19	X			
47.25	+/-0.030	47.25	X			
49.44	+/-0.030	49.44	X			
49.38	+/-0.030	49.375	X			
59.50	+/-0.030	59.50	X			
61.31	+/-0.030	61.31	X			
63.19	+/-0.030	63.19	X			
65.06	+/-0.030	65.06	X			
65.13	+/-0.030	65.13	X			
65.94	+/-0.030	65.94	X			
R9.50	+/-0.030	1.50	X			
R0.25	+/-0.030	1.25	X			

Measured by: IB	Audited by: S. 10/11/15	Prototype Approval:	N/A
Date: 9-4-15	Date: 09/04/15	Date:	N/A
Rev	Date	Change	Revised by
A	08.04.17	New Issue	KJ/DD
			Approved
			DD



D3655-1 PANEL

RELEASED
08.07.30/17

D3655-1 NOTES:

1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAKS: HORIZONTAL DIMENSIONS: 0.005 TO 0.010 MAX

6) IDENTIFICATION: PART AND B/N ON SMOOTH SIDE OF PART

7) KEY: 1/10

8) ORDER: 1/10

9) AMENDMENT: 1/10

10) NOTICE: 1/10

11) RETURN TO: 1/10

12) UNCONTROLLED COPY: 1/10

13) ORDER: 1/10

14) AMENDMENT: 1/10

15) NOTICE: 1/10

16) RETURN TO: 1/10

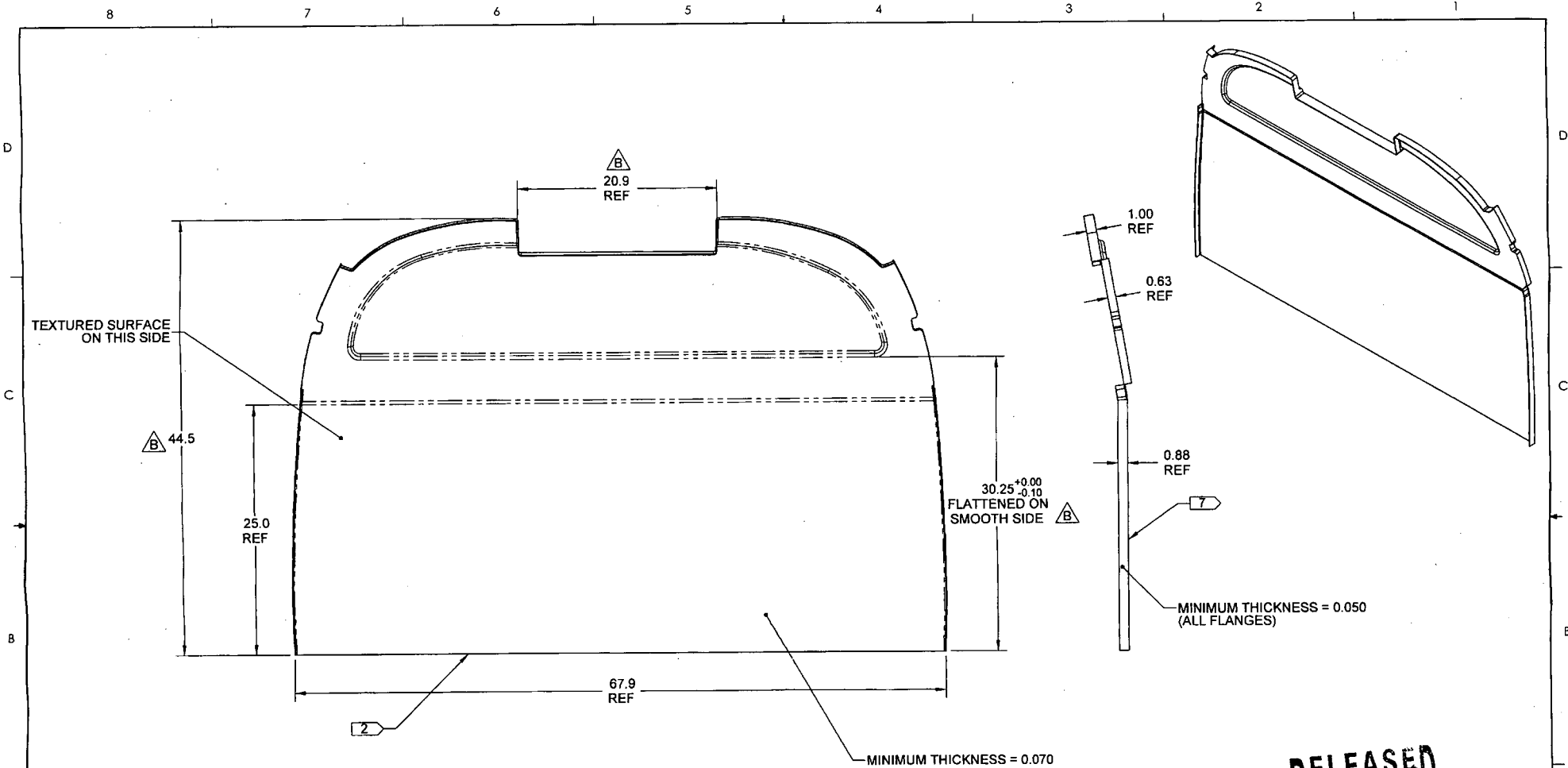
17) UNCONTROLLED COPY: 1/10

18) ORDER: 1/10

19) AMENDMENT: 1/10

20) NOTICE: 1/10

B	44.5 WAS 45.5 (ZN C8-2); 20.9 WAS 19.9 (ZN D5-2); DELETE REFERENCE DIMENSION 2.4 (ZN D8-2); ADD 30.25 DIMENSION FOR TRIMMING (ZN C3-2); REASON: DRAFTING ERROR	PH	08.06.16
A	NEW ISSUE	LE	08.03.03
REV.	DESCRIPTION		BY DATE
DESIGN	LE		
DRAWN	LE		
CHECKED	DRAWING NO.		REV.
MFG. APPR.	D3655		SHEET 1 OF 2
APPROVED	TITLE		SCALE
DE APPR.	PANEL		NTS
DATE	08.06.16		
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D3655-3 PANEL

RELEASED
08-09-30-14

D3655-3 NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXX.093-F6006-07)
- 2) TOOLING: THERMOFORM PER MOLD DT8985 PER QSI 022 TRIM PER MOLD DT8985 EXCEPT WHERE NOTED
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 8) WEIGHT: 1.8 lbs

DESIGN	LE	DART AEROSPACE LTD	
DRAWN	PR	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG APPR.		D3655	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PANEL	NTS
DATE	08.06.16	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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NO. 2009
WORK ORDER
WITHOUT NOTICE
TO AMENDMENT
CONTROLLED COPY
RETURN TO
ENGINEERING
SHOP COPY